

Work Order ID 81396

\*81396\*

Page 1

March-14-12 7:46:59 AM

Item ID: D350-636-012

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 13/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

0.00

0.00

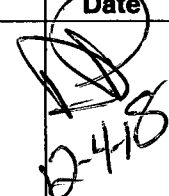
B81396 R+1

PTO

| W/O: 81396 |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|            |      |                    |    |      |     |                                     |                          |
|            |      |                    |    |      |     |                                     |                          |

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)    |                             |                                 |                                                                                                |                           |                          |                          |
|----------|------|-------------------------------------|-----------------------------|---------------------------------|------------------------------------------------------------------------------------------------|---------------------------|--------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A      | Corrective Action Section B |                                 |                                                                                                | Verification<br>Section C | Approval<br>Chief Eng    | Approval<br>QC Inspector |
|          |      |                                     | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date                                                                                 |                           |                          |                          |
| 12.09.18 | 110  | Blade Fitting holes<br>not aligning | CP<br>12.09.18<br>OS1642    | Open aft hole<br>to 40.527      | <br>12-418 | SAD<br>12-01-18           | CP<br>12.09.18<br>OS1642 |                          |
|          |      |                                     |                             |                                 |                                                                                                |                           |                          |                          |
|          |      |                                     |                             |                                 |                                                                                                |                           |                          |                          |

NOTE: Date & initial all entries

# Work Order ID 81396

**\*81396\***

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Item ID: D350-636-012      Accept      **\*N9000040100\***      Setup      Start      **\*NS1\***  
 Revision ID:      Stop      **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 13/03/2012      Start Qty: 1.00      **\*1\***      Cust Item ID:  
 Required Date: 27/03/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                                                                                              | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110                            |                                                                                                                                                                                                                                       | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   | Skidtubes                                                                                                                                                                                                                             |                      |         |        |              |               |               |                  |                |
| Skidtubes                      | <b>Memo</b>                                                                                                                                                                                                                           | 0.00                 |         |        |              |               |               |                  |                |
| Skidtubes                      | 1- Pick D2600-3 Bent                                                                                                                                                                                                                  |                      |         |        |              |               |               |                  |                |
|                                | 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside ✓<br>AFT end per dwg D2750                                                                                                                                     |                      |         |        |              |               |               |                  |                |
|                                | 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", ✓<br>deburr.                                                                                                                                          |                      |         |        |              |               |               |                  |                |
|                                | 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade ✓<br>fitting                                                                                                                                         |                      |         |        |              |               |               |                  |                |
|                                | 5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓                                                                                                                                                           |                      |         |        |              |               |               |                  |                |
|                                | 6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill ✓<br>Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)                                                                    |                      |         |        |              |               |               |                  |                |
|                                | 7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ✓<br>***SECOND SIDE***                                                                                                                                   |                      |         |        |              |               |               |                  |                |
|                                | 8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting ✓<br>location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up<br>holes for ground handling and detail L to 0.500" (8 holes per side) |                      |         |        |              |               |               |                  |                |
|                                | 9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to ✓<br>0.297".                                                                                                                                                 |                      |         |        |              |               |               |                  |                |
|                                | 10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓                                                                                                                                                                  |                      |         |        |              |               |               |                  |                |

*Handwritten:* 3/15/12-03-21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**\*81396\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 13/03/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 27/03/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: *m/20/64* *BE*

A/R Aluminum Rod batch:

12-Grind welds flush as per Dwg D2750

**\*120\***

QC10- Inspect visual per QSI004- ground welds

0.00

## Quality Control

## Memo

0.00

**\*130\***

QC5- Inspect part completeness to step on W/O

0.00

## Quality Control

## Memo

0.00

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 81396****\*81396\***

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140                            | Chemical Conversion Coat per QSI005 4.1 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |                                         |                      |         |        |              |               |               |                  |                |
| 150                            | QC7-Inspect Chemical Conversion Coat    | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                         |                      |         |        |              |               |               |                  |                |

2/6 12-4-19

DP 12-4-19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Work Order ID 81396

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Item ID: D350-636-012

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 13/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

0.00

\*160\*

Skidtubes

0.00

Skidtubes

Skidtubes

Memor

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M12021

exp. date: 2013/01/04

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: M120854

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

CF 12-4-19

BB 12/04/23

- DE 12/04/24

DEC 12-4-24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 81396****\*81396\***

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March-14-12 7:46:59 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool# | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|-------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|-------|--------------|---------------|---------------|------------------|----------------|

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CO  
12-4-24

5/17/02

5/17/02

Plt →

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: Landing Gear / skid tubes NCR: Yes No DQA: Not Date: 12/05/14  
 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 12/5/14

| NCR:    |      | WORK ORDER NON-CONFORMANCE (NCR)                                                                                                            |                             |                                                                                                            |                |                           |                       |                          |
|---------|------|---------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|------------------------------------------------------------------------------------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE    | STEP | Description of NC<br>Section A                                                                                                              | Corrective Action Section B |                                                                                                            |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|         |      |                                                                                                                                             | Initial<br>Chief Eng        | Action Description<br>Chief Eng                                                                            | Sign &<br>Date |                           |                       |                          |
| 12/4/14 | #    | Found at inspection that the Fwd most saddle hole (15" from aft) doesn't align.<br>13" + 12"<br><del>Re pattern when welding process.</del> | CP<br>12.04.14              | Drill out + Remove x-bolt spacer in this location<br>15th hole from aft                                    | CP<br>12-4-25  | S<br>12/15/12             | CP<br>12.04.14        | S<br>12/14/14            |
|         |      | RC not drilled correctly<br>LOA                                                                                                             | CP<br>12.04.14              | Position x-bolt spacer in correct location + weld in<br>new D2743 B B1965 B3<br>A/E M120254<br>Per 002004. | BE<br>12-04-25 | S<br>12/15/12             | CP<br>12.04.14        | S<br>12/14/14            |
|         |      |                                                                                                                                             |                             | Re grind + Reburn                                                                                          | BE<br>12-04-25 | S<br>12/15/12             |                       |                          |
|         |      |                                                                                                                                             |                             |                                                                                                            |                |                           |                       |                          |

NOTE: Date &amp; initial all entries

# Work Order ID 81396

**\*81396\***

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March-14-12 7:46:59 AM

Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 13/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                              | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp               |
|--------------------------------|---------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| 190                            | Pressure Wash per QSI005 4.3                                                          | 0.00                 |         |        |              | <i>3/6</i>    |               | <i>12-5-3</i>    |                              |
| <b>*190*</b>                   |                                                                                       |                      |         |        |              |               |               |                  |                              |
| HandFinish                     | Memo                                                                                  | 0.00                 |         |        |              |               |               |                  |                              |
| Hand Finishing                 | Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.                      |                      |         |        |              |               |               |                  |                              |
| 200                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum                                          | 0.00                 |         |        |              | <i>IX</i>     | <i>q</i>      |                  | <i>ML</i><br><i>12/05/03</i> |
| <b>*200*</b>                   |                                                                                       |                      |         |        |              |               |               |                  |                              |
| Powdercoat                     | Memo                                                                                  | 0.00                 |         |        |              |               |               |                  |                              |
| Powder Coating                 | START TIME: <i>1:40</i><br>OVEN TEMPERATURE: <i>3200F</i><br>FINISH TIME: <i>2:10</i> |                      |         |        |              |               |               |                  |                              |
| 210                            | QC3- Inspect Part Finish                                                              | 0.00                 |         |        |              | <i>1311</i>   | <i>q</i>      |                  | <i>ML</i><br><i>12/05/03</i> |
| <b>*210*</b>                   |                                                                                       |                      |         |        |              |               |               |                  |                              |
| QC                             | Memo                                                                                  | 0.00                 |         |        |              |               |               |                  |                              |
| Quality Control                | Inspect for foreign object per QSI 024                                                |                      |         |        |              |               |               |                  |                              |

*M121134*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 81396

**\*81396\***

Page 8

March-14-12 7:46:59 AM

Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 13/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                             | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230                            | HandFinishing                                                                                                                                                        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*230*</b>                   |                                                                                                                                                                      |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                                                                                                                                                                 | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 | 1-Install inserts as per dwg D2750                                                                                                                                   |                      |         |        |              |               |               |                  |                |
|                                | 2-Inspect for Foreign Objects                                                                                                                                        |                      |         |        |              |               |               |                  |                |
|                                | 3-Spray inside of tube with "LPS-3"<br>batch: <u>N/A</u>                                                                                                             |                      |         |        |              |               |               |                  |                |
|                                | 4-Install blade fitting D3488-042, wearshoes and ground handling hardware as<br>per dwg D2750<br>SIKA FLEX 241<br>BATCH: <u>AA 121221</u><br>EXP DATE: <u>13/6/1</u> |                      |         |        |              |               |               |                  |                |
|                                | 5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube<br>A/R 55-o'ring lube batch: <u>AA 1103-18</u>                                                      |                      |         |        |              |               |               |                  |                |
|                                | 6-Coat all exposed fasteners with "LPS Procyon"<br>batch: <u>AA 114596</u>                                                                                           |                      |         |        |              |               |               |                  |                |

1 RY d all n/05/01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Work Order ID 81396


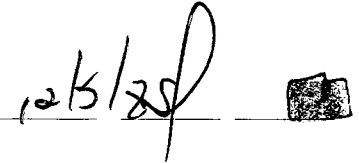
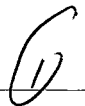
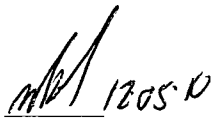
\*81396\*

Page 9

March-14-12 7:46:59 AM

Item ID: D350-636-012 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 13/03/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID         | Operation<br>Description                                  | Set Up/<br>Run Hours      | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty                                                                         | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                                                                        |
|----------------------------------------|-----------------------------------------------------------|---------------------------|---------|--------|--------------|---------------------------------------------------------------------------------------|---------------|------------------|---------------------------------------------------------------------------------------|
| 240<br>*240*<br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>0.00<br>5/12/15/8 |         |        |              |    |               |                  |                                                                                       |
| 250<br>*250*<br>Packaging<br>Packaging | Pick Kit<br><br>Memo                                      | 0.00<br>0.00              |         |        |              |                                                                                       | 12/15/25      |                  |   |
| 260<br>*260*<br>QC<br>Quality Control  | QC4- 100% Inspect kits for completeness<br><br>Memo       | 0.00<br>0.00              |         |        |              |  |               |                  |  |

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 81396

**\*81396\***

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March-14-12 7:46:59 AM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270                            |                                             | 0.00                 |         |        |              |               |               |                  |                |
| <b>*270*</b>                   | Packaging                                   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                        | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Package as per PPP D350-636-012             |                      |         |        |              |               |               |                  |                |
|                                |                                             |                      |         |        |              |               |               |                  |                |
| 280                            |                                             | 0.00                 |         |        |              |               |               |                  |                |
| <b>*280*</b>                   | QC21- Final Inspection - Work Order Release |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

Rev I

1X 12-5-10

12/5/10

MW 12/05/10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:47:04 AM

Page 1

Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-3-BENT

Manufactured

No

110

Each

25.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

① GST-12-03-21

### Location

### Loc Qty

### Loc Code

LG

25

66875

7

73253

1

75021

1

75022

1

75023

1

81330

14

D2744

Manufactured

No

110

Each

60.0000

1

1

\*D2744\*

Cap

\*\*

DE 12/03/22

### Location

### Loc Qty

### Loc Code

LG002

60

62715

1

70881

10

71861

7

78900

42

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:47:04 AM

Page 2

Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

8.0000

1

1

\*D2739\*

350 I Beam

\*\*

①

CF 12-4-19

Location

Loc Qty

Loc Code

LG

8

72155

1

80083

7

D2743

Manufactured No

160 Each

248.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

ZE 12/04/23

B 81965 x8

Location

Loc Qty

Loc Code

LG001

248

67766

4

68251

3

73403

64

74445

1

78603

76

79517

100

D3490-3

Manufactured No

160 Each

38.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

BE 12/04/23

B 82016 x4

Location

Loc Qty

Loc Code

LG001

38

78800

38

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 81396

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*81396\***

**\*D350-636-012\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

49.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE12/04/23  
B81976 x4

Location

Loc Qty

Loc Code

LG001

49

62450

2

74875

4

77042

3

78793

40

D3631-1

Manufactured No

230

Each

223.0000

8

8

**\*D3631-1\***

Washer

\*\*

HL 12105103

Location

Loc Qty

Loc Code

ST072

223

68062

2

75548

221

B81874

x2

B83588

x6

D3791-1

Manufactured No

230

Each

17.0000

1

1

**\*D3791-1\***

Wearplate

\*\*

HL 12108103

Location

Loc Qty

Loc Code

FP002

17

62239

2

75041

3

78897

12

B83392

x1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:47:04 AM

Page 4

Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

26.0000 1 1

\*D3793-3\*

Wearshoe

\*\*

382166 12/05/03

Location

Loc Qty

Loc Code

FP001

12

382166

XL

80434

12

FP002

14

78935

14

MS21043-6

Purchased No

230 Each

809.0000 4 4

\*MS21043-6\*

NUT

\*\*

382166 12/05/03

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

789

112314

83

117887

6

118384

200

120308

500

XL

D3794-1

Manufactured No

230 Each

24.0000 1 1

\*D3794-1\*

Gasket

\*\*

382167 12/05/03

Location

Loc Qty

Loc Code

FP002

24

75042

12

80435

12

382167

XL

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:47:04 AM

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Work Order ID: 81396

**\*81396\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

209.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

*M 12/05/03*

Location

Loc Qty

Loc Code

FP

50

*8121415*

*x 8*

110915

0

120770

50

FP001

159

110915

14

117460

8

118077

1

118612

3

119438

47

120308

36

120986

50

D2741

Manufactured

No

250

Each

37.0000

1

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

*37516 12/5/8*

Location

Loc Qty

Loc Code

ST

-10

ST466

47

71856

1

76984

36

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81396

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*81396\*

\*D350-636-012\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

184.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

21 1105103

Location

Loc Qty

Loc Code

FG

40

11121243

24

102472

40

ST277

144

118686

3

119438

1

120072

40

120360

100

NAS1611-013

Purchased

No

230

Each

168.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

21 1105163

Location

Loc Qty

Loc Code

FP001

168

116582

5

117291

2

117887

53

119623

36

120360

22

120910

50

11121584

28

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

623.0000

4

4

\*AN3C6A\*

BOLT

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

1

111982

1

ST351

622

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

133

120693

400

yl

NAS1149C0832R

Purchased

No

230

Each

304.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

ST297

304

114915

304

yl

D3536-25

Manufactured

No

230

Each

16.0000

1

1

\*D3536-25\*

Gasket

\*\*

yl 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

16

78902

16

B03391

yl

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81396

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*81396\*

\*D350-636-012\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

31.0000

1

1

\*D3794-3\*

Gasket

\*\*

94 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

31

B83396

X1

74530

2

78895

5

80436

24

AN3C5A

Purchased No

230

Each

998.0000

34

34

\*AN3C5A\*

Bolt

\*\*

94 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

991

X121441

V34

116419

28

117343

13

117764

7

117872

2

119749

23

120423

918

D3537-1

Manufactured No

230

Each

151.0000

3

3

\*D3537-1\*

Wearpad

\*\*

94 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

104

79833

50

B81959

V3

79835

54

FP002

47

69817

5

79834

42

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

|                   |              |    |     |      |         |    |    |          |
|-------------------|--------------|----|-----|------|---------|----|----|----------|
| D3535-25          | Manufactured | No | 230 | Each | 19.0000 | 1  | 1  |          |
| <b>*D3535-25*</b> |              |    |     |      |         |    |    |          |
| Wearshoe          |              |    |     |      |         | ** | ML | 12/05/03 |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001    | 14      | B82156   |
| 62233    | 1       |          |
| 80331    | 13      |          |
| FP002    | 5       |          |
| 77617    | 5       |          |

|                  |              |    |     |      |         |    |    |          |
|------------------|--------------|----|-----|------|---------|----|----|----------|
| D3492-3          | Manufactured | No | 230 | Each | 69.0000 | 8  | 8  |          |
| <b>*D3492-3*</b> |              |    |     |      |         |    |    |          |
| Plug             |              |    |     |      |         | ** | ML | 12/05/03 |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP-A     | 69      | B83099   |
| 78600    | 69      |          |

|                     |                   |           |    |     |      |        |          |          |
|---------------------|-------------------|-----------|----|-----|------|--------|----------|----------|
| AN960C10L           | NAS1149C0332<br>R | Purchased | No | 230 | Each | 0.0000 | 38       | 38       |
| <b>*AN960C10L *</b> |                   |           |    |     |      |        |          |          |
| washer              |                   |           |    |     |      | **     | (x38) ML | 12/05/03 |

|                            |              |    |     |      |         |    |    |          |
|----------------------------|--------------|----|-----|------|---------|----|----|----------|
| D3488-042                  | Manufactured | No | 230 | Each | 19.0000 | 1  | 1  |          |
| <b>*D3488-042*</b>         |              |    |     |      |         |    |    |          |
| Blade Fitting Assembly, RH |              |    |     |      |         | ** | ML | 12/05/03 |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002    | 19      |          |
| 62003    | 1       |          |
| 75068    | 9       | B82258   |
| 77015    | 9       |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81396

**\*81396\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,134.000

38

38

**\*AI S4-1032-225\***

Insert

\*\*

12/05/03

Location

Loc Qty

Loc Code

ST281

1021

108696

146

110768

62

118386

55

118966

68

120671

690

11121269

x38

ST282

113

120410

100

120451

13

D3492-1

Manufactured

No

230

Each

130.0000

8

8

**\*D3492-1\***

Plug

\*\*

12/05/03

Location

Loc Qty

Loc Code

FP002

130

69531

8

74444

2

76235

20

77037

100

B83098

x8

D3793-1

Manufactured

No

230

Each

18.0000

1

1

**\*D3793-1\***

Wearshoe

\*\*

12/05/03

Location

Loc Qty

Loc Code

FP001

18

77029

6

78901

12

B83393

x1

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Work Order ID: 81396

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*81396\*

\*D350-636-012\*

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

65.0000

1

1

\*AN8C35A\*

BOLT

\*\*

12/05/03

Location

Loc Qty

Loc Code

FP002

64

115960

1

117834

10

118286

53

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

85.0000

1

1

\*MS21083C8\*

NUT

\*\*

12/05/03

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

11121185

12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

136.0000

8

8

\*D2745\*

Bushing

\*\*

12/05/03

Location

Loc Qty

Loc Code

FP

100

B81964

x8

79518

100

FP001

36

69529

1

76142

1

78597

34

AN6C44A

Purchased No

230

Each

107.0000

4

4

\*AN6C44A\*

BOLT

\*\*

11/05/03

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

105

120095

12

120143

25

120465

27

120641

21

121013

20

11/12/167

x4

D3532-1

Manufactured No

250

Each

39.0000

2

2

\*D3532-1\*

Spacer

\*\*

B82041

Location

Loc Qty

Loc Code

ST053

39

78839

39

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**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81396

\*81396\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

85.0000

2

\*\*

\*MS21083C8\*  
NUT

②  
M121 524

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

NAS1149D0863J

Purchased

No

250

Each

231.0000

2

\*\*

\*NAS1149D0863.J\*  
WASHER

2  
SP

Location

Loc Qty

Loc Code

ST298

231

118078

36

119307

95

120308

100

2

D3493-1

Manufactured

No

250

Each

66.0000

2

\*\*

\*D3493-1\*  
Washer

②  
382023 12/5/85

Location

Loc Qty

Loc Code

ST050

66

70697

2

77573

24

78835

40

March-14-12 7:47:04 AM

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-14-12 7:47:04 AM

Page 14

Work Order ID: 81396

**\*81396\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

51.0000

2

2

**\*AN8C21A\***

BOLT

\*\*

M121067 12/5/8



Location

Loc Qty

Loc Code

ST343

51

118758

5

120094

42

120872

4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER   | DESCRIPTION                                                |
|-------------|-------------|-------------|-------------|---------------|------------------------------------------------------------|
| X           |             |             |             | D2750-041     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             | X           |             |             | D2750-042     | 350 SKIDTUBE ASSEMBLY, RH                                  |
|             |             | X           |             | D2750-043     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             |             |             | X           | D2750-044     | 350 SKIDTUBE ASSEMBLY, RH                                  |
| 1           | 1           | 1           | 1           | D2739         | WEB                                                        |
| 8           | 8           | 8           | 8           | D2743         | SPACER                                                     |
| 1           | 1           | 1           | 1           | D2744         | CAP                                                        |
| 8           | 8           | 8           | 8           | D2745         | BUSHING                                                    |
| 1           |             |             |             | D2750-1       | SKIDTUBE WELDMENT, LH                                      |
|             | 1           |             |             | D2750-2       | SKIDTUBE WELDMENT, RH                                      |
|             |             | 1           |             | D2750-3       | SKIDTUBE WELDMENT, LH                                      |
|             |             |             | 1           | D2750-4       | SKIDTUBE WELDMENT, RH                                      |
| 1           |             | 1           |             | D3488-041     | BLADE FITTING, LH                                          |
|             | 1           |             | 1           | D3488-042     | BLADE FITTING, RH                                          |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER                                                     |
| 4           | 4           |             |             | D3490-3       | SPACER                                                     |
|             |             | 4           | 4           | D3490-5       | SPACER                                                     |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY                                              |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY                                              |
|             |             | 8           | 8           | D3492-045     | PLUG ASSEMBLY                                              |
| 1           | 1           | 1           | 1           | D3535-25      | WEARSHOE                                                   |
| 1           | 1           | 1           | 1           | D3536-25      | GASKET                                                     |
| 3           | 3           | 3           | 3           | D3537-1       | WEARPAD                                                    |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER                                                     |
| 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE                                                  |
| 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE                                                   |
| 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE                                                   |
| 1           | 1           | 1           | 1           | D3794-1       | GASKET                                                     |
| 1           | 1           | 1           | 1           | D3794-3       | GASKET                                                     |
| 38          | 38          | 38          | 38          | ALS4-1032-225 | INSERT (OR ALS7-1032-225,<br>AKS4-1032-225, AELS-1032-225) |
| 34          | 34          | 34          | 34          | AN3C5A        | BOLT                                                       |
| 4           | 4           | 4           | 4           | AN3C6A        | BOLT                                                       |
| 4           | 4           | 4           | 4           | AN6C44A       | BOLT                                                       |
| 1           | 1           | 1           | 1           | AN8C35A       | BOLT                                                       |
| 38          | 38          | 38          | 38          | AN960C10L     | WASHER                                                     |
| 1           | 1           | 1           | 1           | AN960C816L    | WASHER                                                     |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT                                                        |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT                                                        |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER                                                     |

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER  
NO. 01396 MCT  
12/03/14

RELEASED

|            |                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                   |               |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| F          | INCORPORATE DSI 9413;<br>QTY (3) D3537-1 WAS QTY (5) (ZN C8-1);<br>D3791-1/3 REPLACES D3535-13/35 (ZN C8-1);<br>D3794-1/3 REPLACES D3536-13/35 (ZN B8-1);<br>ADD D3791-1 (ZN C8-1);<br>WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED<br>(8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1);<br>D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11);<br>ADD NOTE 12 AND 13 (ZN A6-1);<br>REASON: REF. NCR 08-043 | PH                                                                                                                                                                                                                                                                                | 08.07.16      |
| E          | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1;<br>REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10)<br>NAS1515H8L; REMOVE D2741; QTY (2) AN960C816;<br>REMOVE QTY (2) MS21083C8                                                                                                                                                                                        | CB                                                                                                                                                                                                                                                                                | 07.05.17      |
| D          | ADD HOLES AND SPACERS FOR APICAL FLOATS;<br>INCORPORATE DEC 9133/9157                                                                                                                                                                                                                                                                                                                                       | PH                                                                                                                                                                                                                                                                                | 06.01.05      |
| C          | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740                                                                                                                                                                                                                                                                                                                                                            | CP                                                                                                                                                                                                                                                                                | 98.11.18      |
| B          | CHANGE MS24694-S293 TO AN8-16A                                                                                                                                                                                                                                                                                                                                                                              | CP                                                                                                                                                                                                                                                                                | 98.09.01      |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                                                                                                                                                   | DS                                                                                                                                                                                                                                                                                | 98.04.16      |
| REV.       | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                                 | BY                                                                                                                                                                                                                                                                                | DATE          |
| DESIGN     | PA                                                                                                                                                                                                                                                                                                                                                                                                          | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                          |               |
| DRAWN      | RAH                                                                                                                                                                                                                                                                                                                                                                                                         | PORT HADLOCK, WA                                                                                                                                                                                                                                                                  |               |
| CHECKED    | AK                                                                                                                                                                                                                                                                                                                                                                                                          | DRAWING NO.                                                                                                                                                                                                                                                                       | REV. F        |
| MFG. APPR. | AK                                                                                                                                                                                                                                                                                                                                                                                                          | D2750                                                                                                                                                                                                                                                                             | SHEET 1 OF 11 |
| APPROVED   | AK                                                                                                                                                                                                                                                                                                                                                                                                          | TITLE                                                                                                                                                                                                                                                                             | SCALE         |
| DE APPR.   | AK                                                                                                                                                                                                                                                                                                                                                                                                          | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                             | NTS           |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

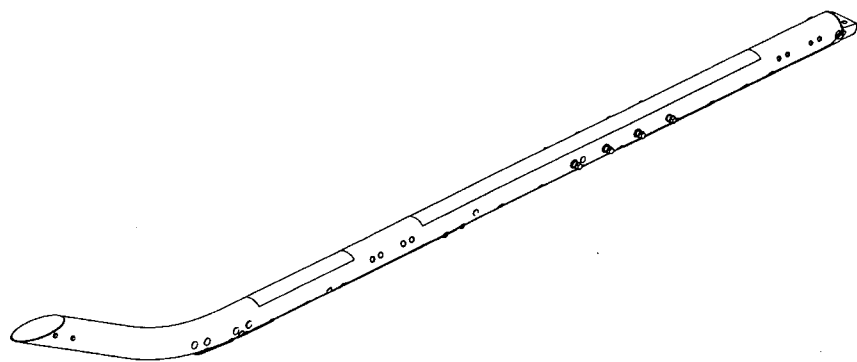
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

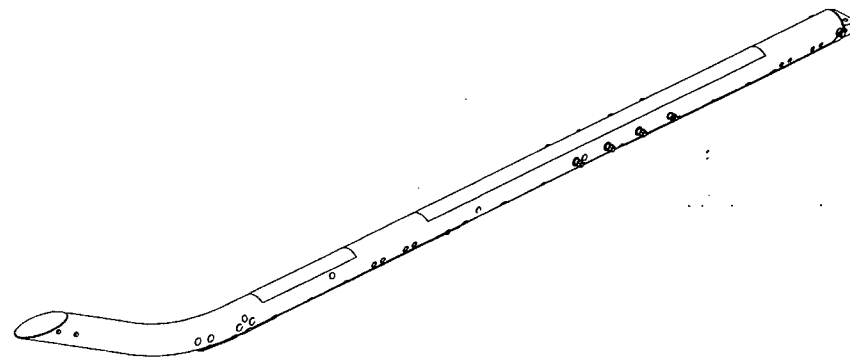
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

81396



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08.07.16

|            |          |                                                                                                                                                                                                                                                                                                             |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PC       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                             |               |
| DRAWN      | AD       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                            |               |
| CHECKED    | JA       | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. F        |
| MFG. APPR. | MA       | D2750                                                                                                                                                                                                                                                                                                       | SHEET 2 OF 11 |
| APPROVED   | MA       | TITLE                                                                                                                                                                                                                                                                                                       | SCALE         |
| DE APPR.   | MA       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                                       | NTS           |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

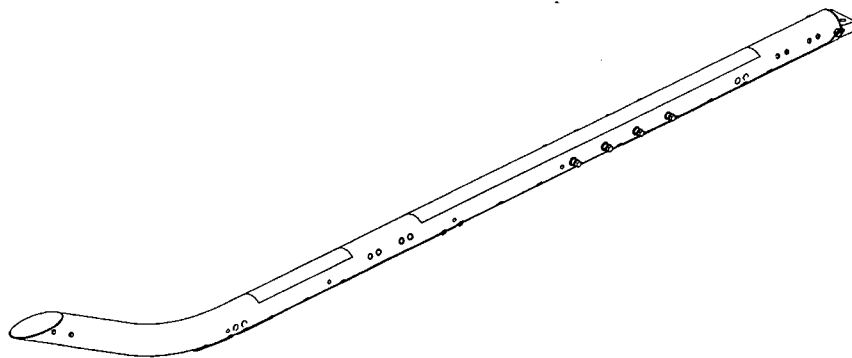
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

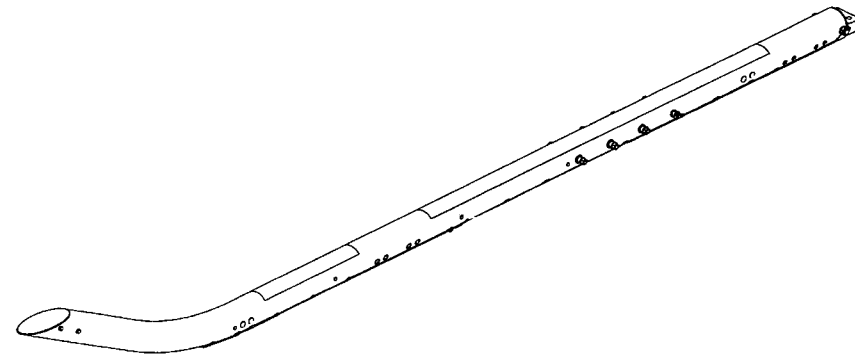
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

8139.6



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08-09-22/111

|            |          |                                                                                                                                                                                                                                                                                                             |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PD       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                             |               |
| DRAWN      | PD       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                            |               |
| CHECKED    | NA       | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. F        |
| MFG. APPR. | NA       | D2750                                                                                                                                                                                                                                                                                                       | SHEET 3 OF 11 |
| APPROVED   | NA       | TITLE                                                                                                                                                                                                                                                                                                       | SCALE         |
| DE APPR.   | NA       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                                       | NTS           |
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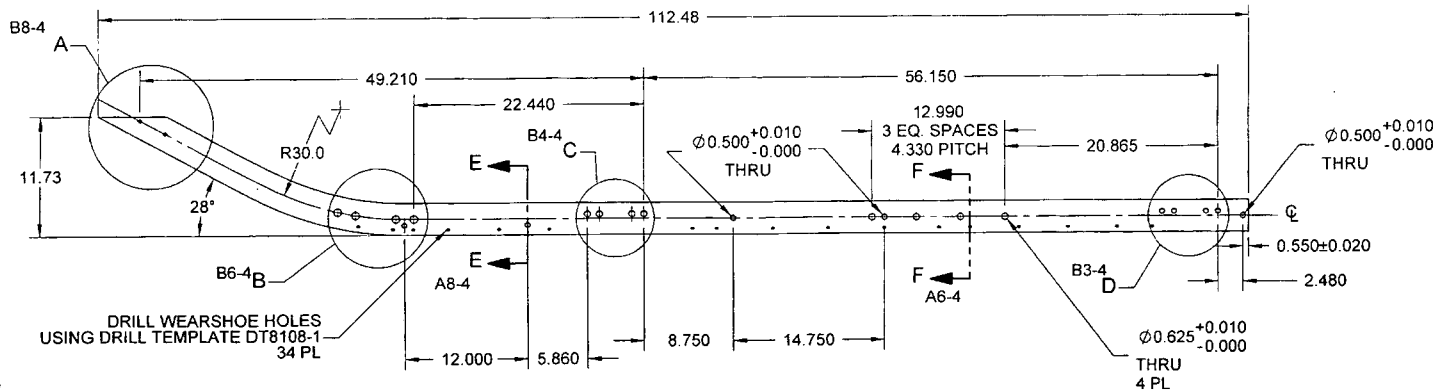
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

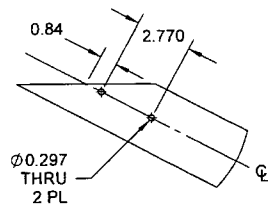
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

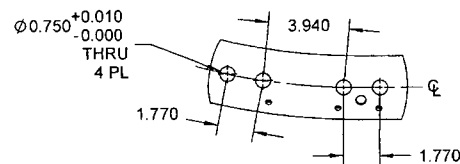
**NOTE:** Date & initial all entries



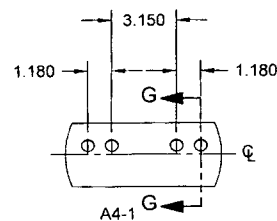
# **D2750-1 LH SKIDTUBE**



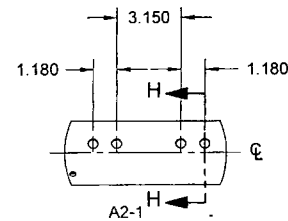
**DETAIL A**  
SCALE 2X



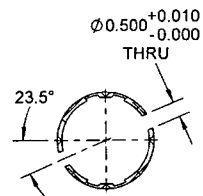
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SCALE 2X



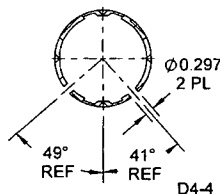
**DETAIL C**  
SCALE 2X



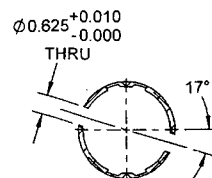
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SCALE 2X



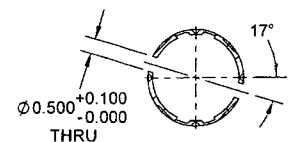
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

|            |          |                                                                                                                                                                                                                                                                                     |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | IN       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                     |               |
| DRAWN      | PH       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                    |               |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. F        |
| MFG. APPR. |          | <b>D2750</b>                                                                                                                                                                                                                                                                        | SHEET 4 OF 11 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                               | SCALE         |
| DE APPR.   |          | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                        | NTS           |
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81396

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

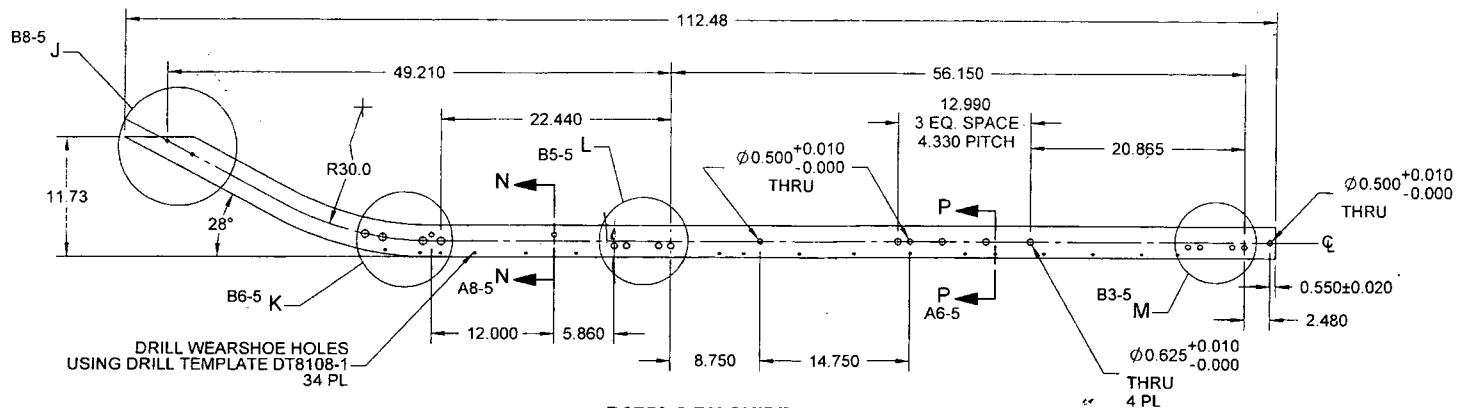
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

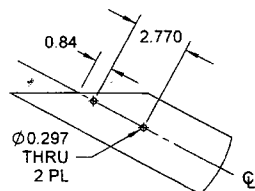
NOTE: Date & initial all entries



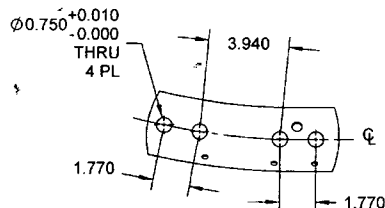
21396



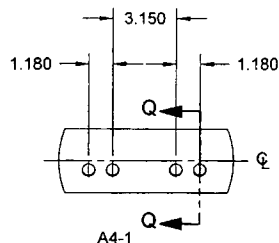
**D2750-2 RH SKIDTUBE**



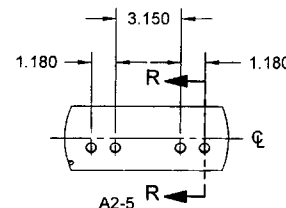
**DETAIL J**  
SCALE 2X



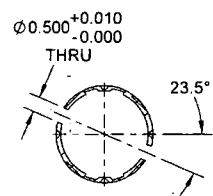
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SCALE 2X



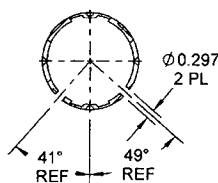
**DETAIL L**  
SCALE 2X



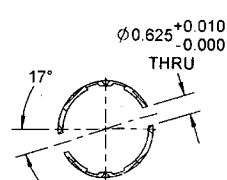
**DETAIL M**  
SCALE 2X



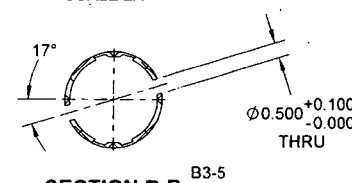
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

|            |          |                                                                                                                                                                                                                                                                                                             |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | REV      | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                             |               |
| DRAWN      | REV      | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                            |               |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. F        |
| MFG. APPR. |          | D2750                                                                                                                                                                                                                                                                                                       | SHEET 5 OF 11 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                                       | SCALE         |
| DE APPR.   |          | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                                       | NTS           |
| DATE       | 08.07.16 | <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |               |

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

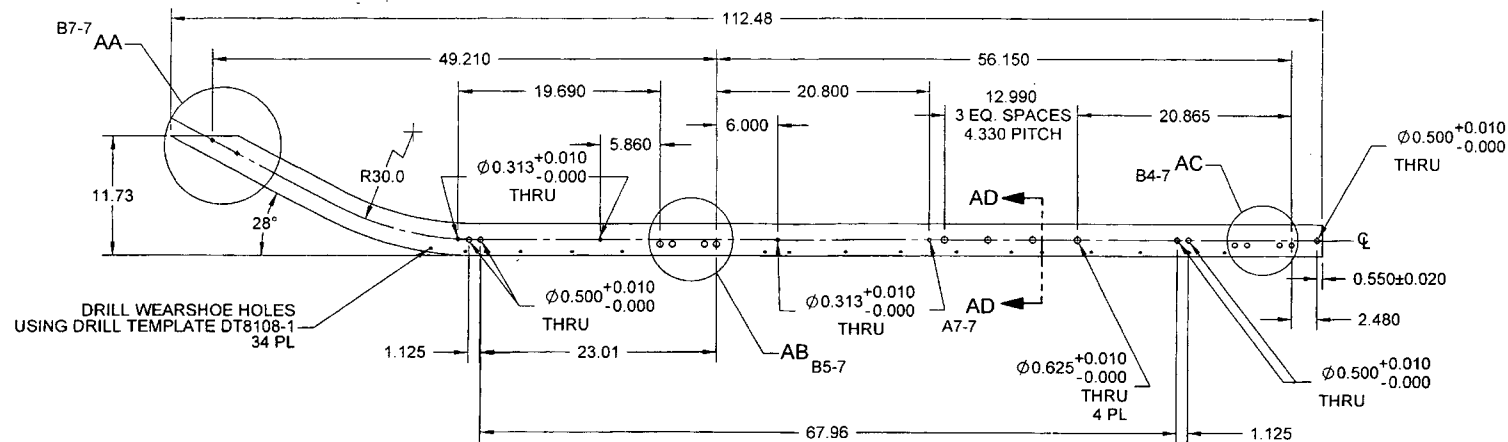
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

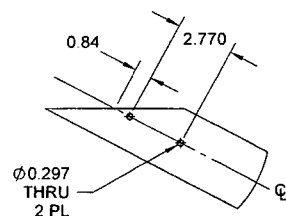
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

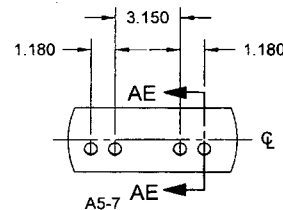
81396



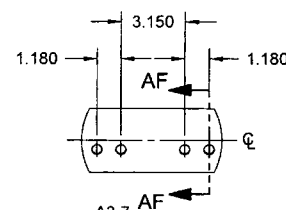
**D2750-4 RH SKIDTUBE**



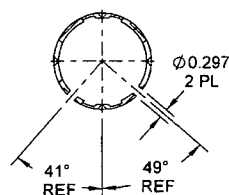
**DETAIL AA**  
SCALE 2X



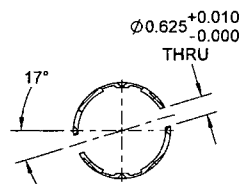
**DETAIL AB**  
SCALE 2X



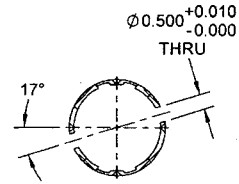
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**

|            |                 |                                                                                                                                                                                                                                                                                                     |               |
|------------|-----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     |                 | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                     |               |
| DRAWN      |                 | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                    |               |
| CHECKED    |                 | DRAWING NO.                                                                                                                                                                                                                                                                                         | REV. F        |
| MFG. APPR. |                 | <b>D2750</b>                                                                                                                                                                                                                                                                                        | SHEET 7 OF 11 |
| APPROVED   |                 | TITLE                                                                                                                                                                                                                                                                                               | SCALE         |
| DE APPR.   |                 | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                        | NTS           |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

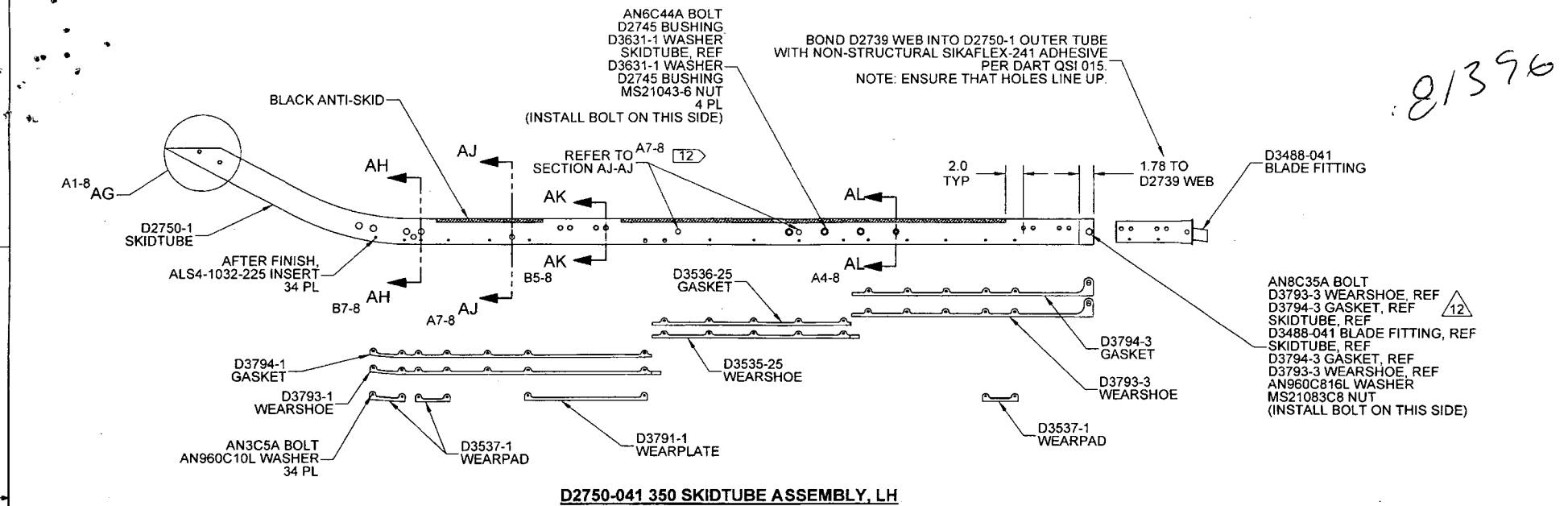
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

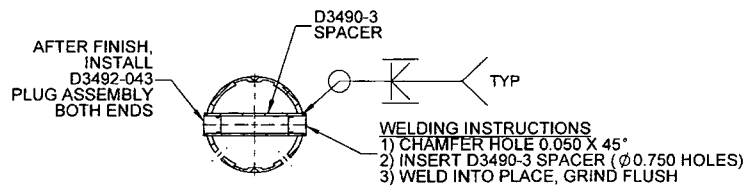
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

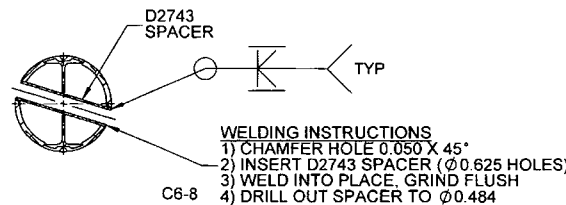
81396



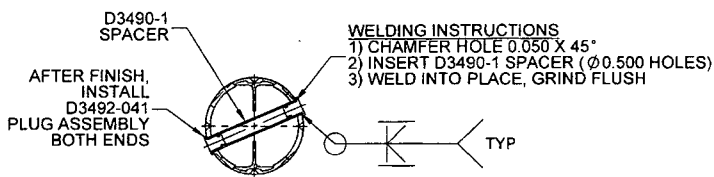
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



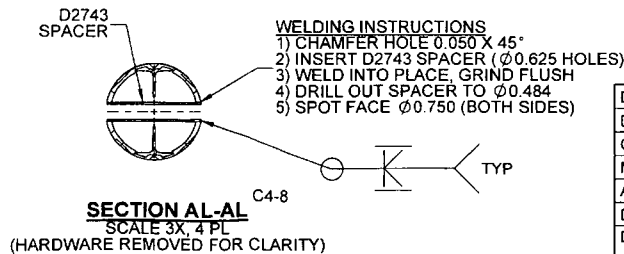
**SECTION AH-AH**  
SCALE 3X, 4 PL



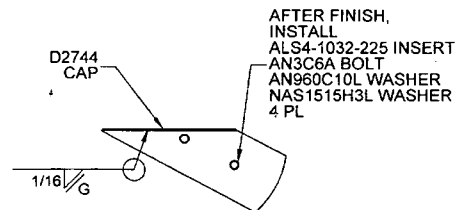
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X

**RELEASED**  
08.07.16

|            |          |                                                                                                                                                                                                                                                                                           |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PA       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                           |               |
| DRAWN      | PA       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                          |               |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                               | REV. F        |
| MFG. APPR. | AK       | <b>D2750</b>                                                                                                                                                                                                                                                                              | SHEET 8 OF 11 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                     | SCALE         |
| DE APPR.   |          | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                              | NTS           |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

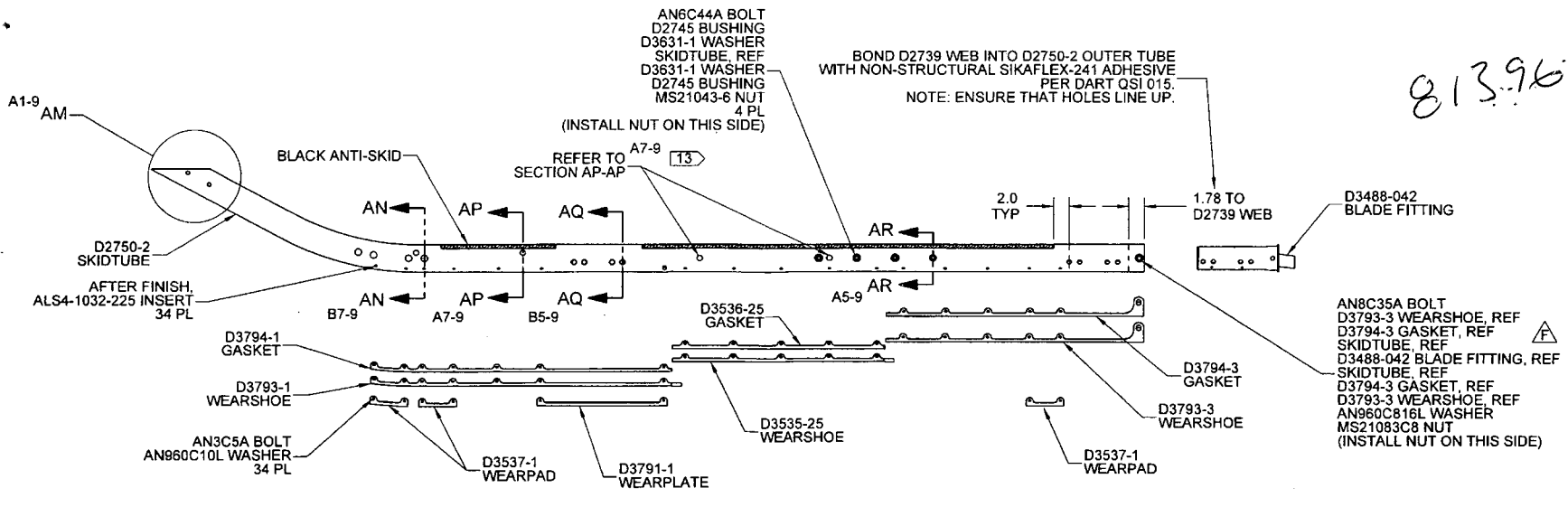
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

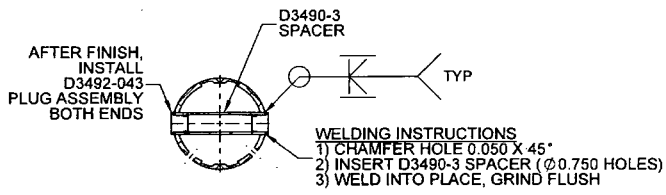
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

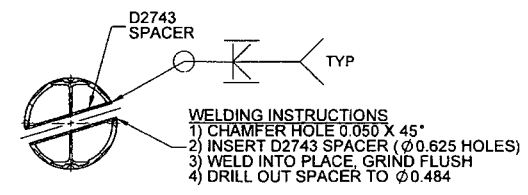
813.96



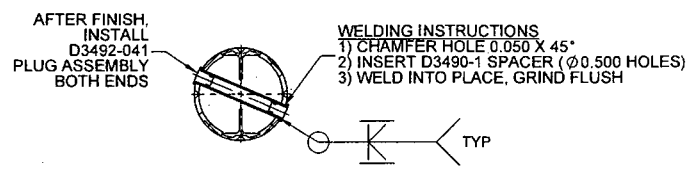
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



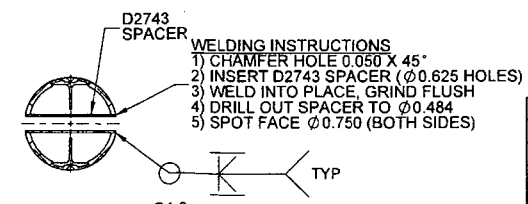
**SECTION AN-AN**  
SCALE 3X, 4 PL



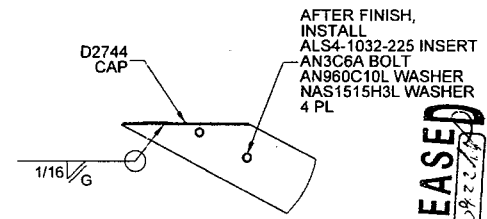
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AM**  
SCALE 2X

|            |          |                                                                                                                                                                                                                                                                               |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | D2750    | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                               |               |
| DRAWN      |          | PORT HADLOCK, WA                                                                                                                                                                                                                                                              |               |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                   | REV. F        |
| MFG. APPR. |          | D2750                                                                                                                                                                                                                                                                         | SHEET 9 OF 11 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                         | SCALE         |
| DE APPR.   |          | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                         | NTS           |
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RELEASED

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

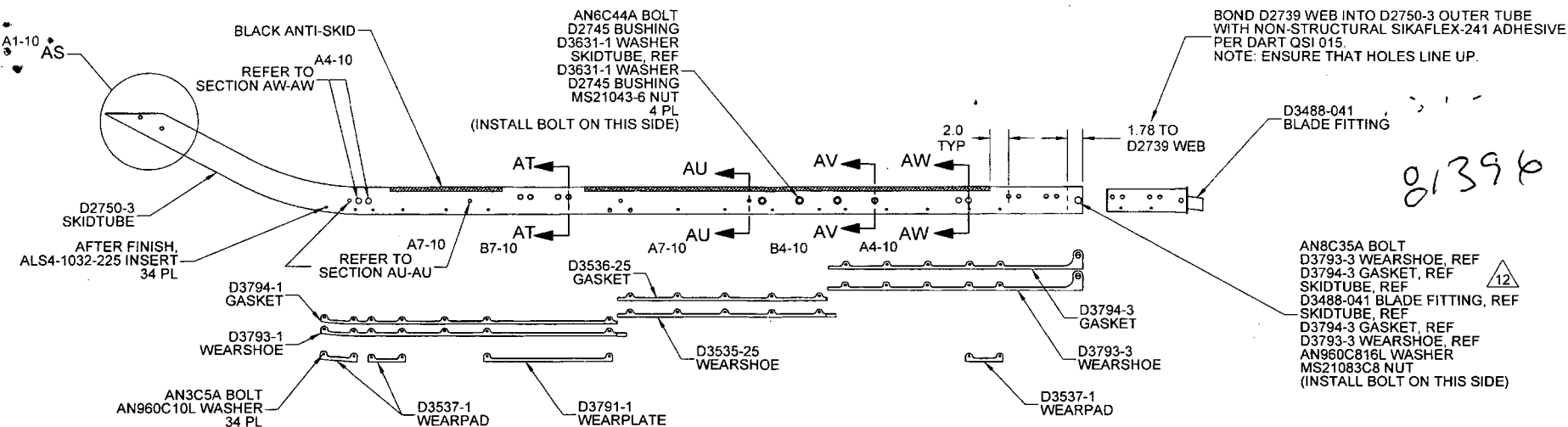
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

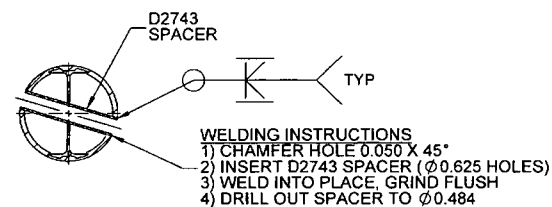
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

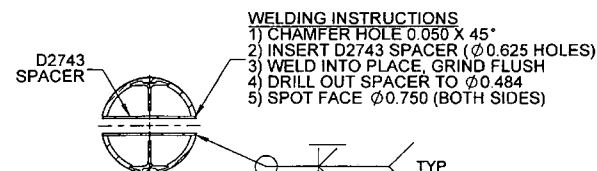




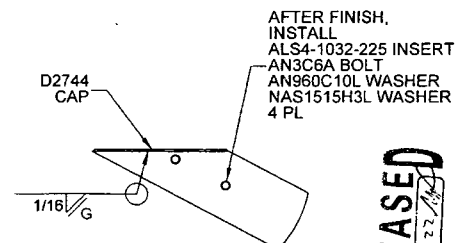
### D2750-043 350 SKIDTUBE ASSEMBLY, LH



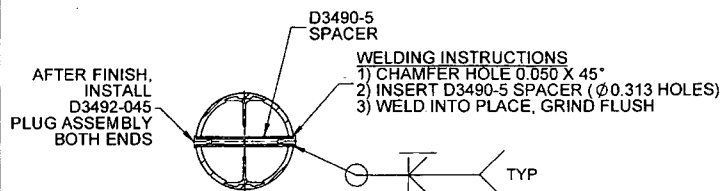
#### SECTION AT-AT SCALE 3X, 4 PL



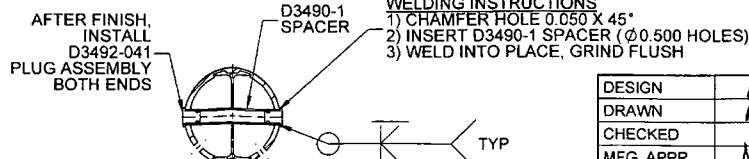
#### SECTION AV-AV SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



#### DETAIL AS SCALE 2X



#### SECTION AU-AU SCALE 3X, 4 PL



#### SECTION AW-AW SCALE 3X, 4 PL

|            |                  |                          |
|------------|------------------|--------------------------|
| DESIGN     | PORT HADLOCK, WA | DART AEROSPACE USA, INC. |
| DRAWN      | REV. F           | REV. F                   |
| CHECKED    | D2750            | DRAWING NO.              |
| MFG. APPR. |                  | SHEET 10 OF 11           |
| APPROVED   |                  | TITLE                    |
| DE APPR.   |                  | 350 SKIDTUBE ASSEMBLY    |
| DATE       | 08.07.16         | SCALE                    |
|            |                  | NTS                      |

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2015-08-22/102

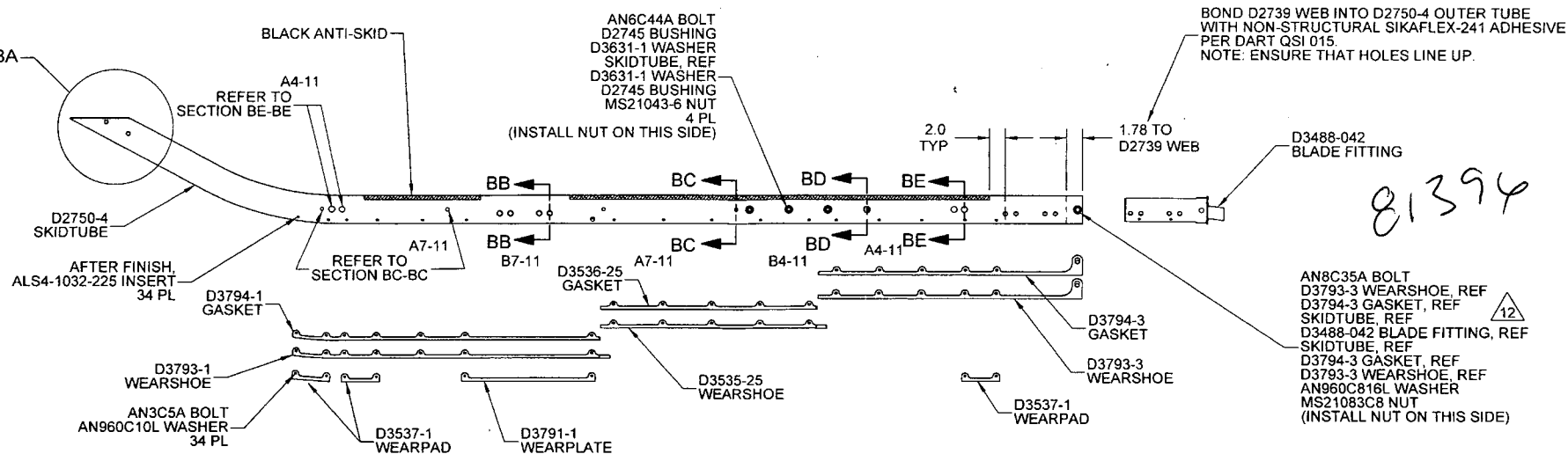
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

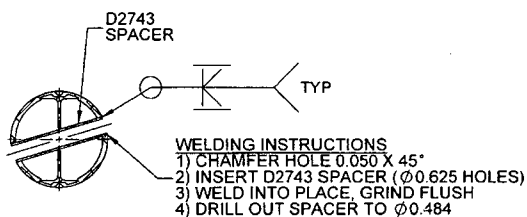
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

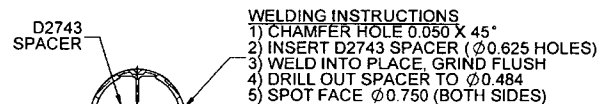
**NOTE:** Date & initial all entries



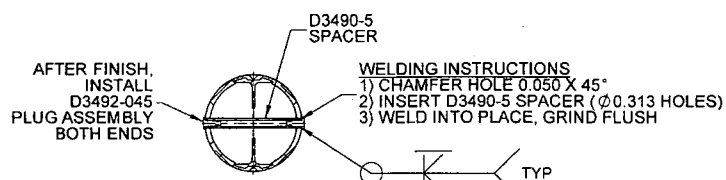
### D2750-044 350 SKIDTUBE ASSEMBLY, RH



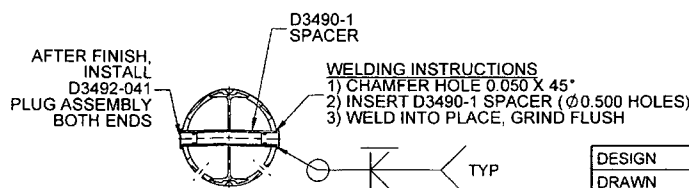
#### SECTION BB-BB SCALE 3X, 4 PL



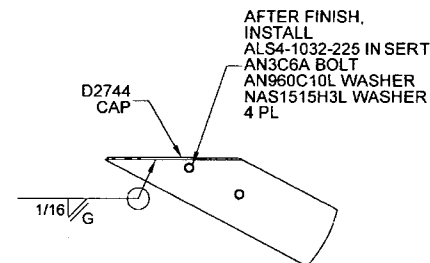
#### SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



#### SECTION BC-BC SCALE 3X, 4 PL



#### SECTION BE-BE SCALE 3X, 4 PL



#### DETAIL BA SCALE 2X

|            |          |                                                                                                                                                                                                                                                                                                     |                |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | PH       | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                                            |                |
| DRAWN      | PH       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                    |                |
| CHECKED    | PH       | DRAWING NO.                                                                                                                                                                                                                                                                                         | REV. F         |
| MFG. APPR. | PH       | D2750                                                                                                                                                                                                                                                                                               | SHEET 11 OF 11 |
| APPROVED   | PH       | TITLE                                                                                                                                                                                                                                                                                               | SCALE          |
| DE APPR.   | PH       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                               | NTS            |
| DATE       | 08.07.16 | <small>COPYRIGHT © 1986 BY DART AEROSPACE USA, INC.<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: 1350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Reed Date of Test Coupon 12-05-01  
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld